



## NOTES

1. THIS IS A ULTRA - HIGH WELDMENT ASSEMBLY (UHV)  
2. ALL MATERIALS ARE 304L STAINLESS STEEL UNLESS OTHERWISE SPECIFIED
3. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
- A) CIMCOUL 5 STAR 49
  - B) TRIM SOL
4. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE CHAMBER NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWING. THE CHAMBER SURFACE VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICRON RMS AFTER ELECTROPOLISHING
5. WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
6. WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10<sup>-10</sup> Torr STANDARD CHAMBER LEAK METER DIVISION, SUCH AS:
- ALCATEL ASM-1107CL  
VARIAN RKN 925 or 936  
HICO MS-9, MS-90 or MS-18  
DU PONT CEC 24-1208
- CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
- FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 HOUR.
7. DIMENSIONS IN [ ] ARE MILLIMETERS AND

6		4" O.D. X 12 THK. WALL, TUBING	304L SST	1	AS REQD
5	#100026	6" O.D. ROTATABLE VACUUM FLANGE	304 SST	3	
4	#100030	8" O.D. ROTATABLE VACUUM FLANGE, 3.81 I.D.	304 SST	3	
3		SHIELD ASSEMBLY	304L SST	1	
2		3.38 X 3.25 X .25 THK. SHIELD	304L SST	2	
1		Ø.75 X .36 THK MOUNTING PLATE	304L SST	1	
QTY		MATERIALS (SEE PARTS LIST)		WELDS - 1 PPS	
PARTS LIST					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p> </div> <div> <p>P8510000-00</p> <p>MUSCIA</p> <p>J. CHANG</p> <p>CHANG/MUSCIA</p> <p>J. CHANG</p> </div> <div> <p>5/3/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> <p>5/20/93</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> <div> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> <p>6/5/97</p> </div> <div> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> <p>QTY</p> </div> </div>					
<div style="display: flex; justify-content: space-between;"> <div> <p>QTY REQUIRED</p> <p>QTY ON HAND</p> <p>QTY TO ORDER</p> <p>QTY IN STOCK</p> <p>QTY IN PROCESS</p> <p>QTY IN TRANSIT</p> <p>QTY IN WAREHOUSE</p> <p>QTY IN SHED</p> <p>QTY IN FIELD</p> <p>QTY IN OTHER</p></div></div>					